

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006839**Date Inspected:** 23-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG cross beam CB1

This QA observed that the contractor has set this Cross Beam (CB) into the superstructure trial assembly. No significant work was observed on this CB during the time this QA was present.

OBG cross beam CB2 (in superstructure trial assembly)

This QA observed ZPMC personnel installing side panel stiffener splice plates. This QA performed random Visual Testing (VT) of the fillet welds joining the floorbeam diaphragm to the FL3's. QA found and marked numerous areas of undercut and overlap on these welds. QA informed ZPMC QA identified as Mr. Shen Xuejun of this and requested that ZPMC's Certified Welding Inspector (CWI) re examine these welds. Mr. Shen said he would have QC look at these welds and would inform this QA when the welds were ready for QA testing.

OBG cross beam CB3 (in superstructure trial assembly)

This QA observed ZPMC personnel match drilling bolt holes on the deck panel at the splice joint to the west

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line using the splice plates as a template. No other significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB4

This QA observed that the contractor has moved this crossbeam to the blast bay for blast and paint. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB5

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB6

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB7

This QA observed ZPMC qualified welding personnel identified as 067954 perform FCAW welding on weld joint identified as FB205-016-014. ZPMC QC identified as Mr. Tian Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

OBG cross beam CB8

This QA observed that the contractor has fit and tack welded one of the side panels to the deck panel and is in the process of fitting and tack welding the floorbeam diaphragms to the deck panel. No other significant work was observed on this crossbeam during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
